

Monday, 4/23/2007 1:52:52 PM  
User: Kim Johnston

## Process Sheet

SPHIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 31998 - 1		
Estimate Number	: 12712		
P.O. Number	: N/A	Part Number	: D35371
This Issue	: 4/23/2007 / S.O. No. : N/A	Drawing Number	: D3537 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B PH 07.04.26
Previous Run	: 31937	Material	: N/A
Written By	: <u>HA 07.04.26</u>	Due Date	: 4/30/2007
Checked & Approved By	: <u>HA 07.04.26</u>	Qty:	100 Um: Each
Comment	: Est Rev: A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s)  
M304S16GA .063" 304 SS SHEET  
Batch: M101873 X

ml 07.04.26

105  
104

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3537  
Dwg Rev: B  
Prog Rev: B

ml 07.04.27

105  
104

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07.04.27

105  
104

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/04/30

105  
104

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.  
2-Identify as D3537-1

SB 07/04/30

105  
104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/05/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:52 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31998

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R

2059B Hardcoat

12755

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

FC 07/05/04

(40)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 07/15/04

(40)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/15/04

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 07/05/04

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 07/05/04

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F P 18

M 07/05/04

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

M 07/05/04

Job Completion



M 07/05/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

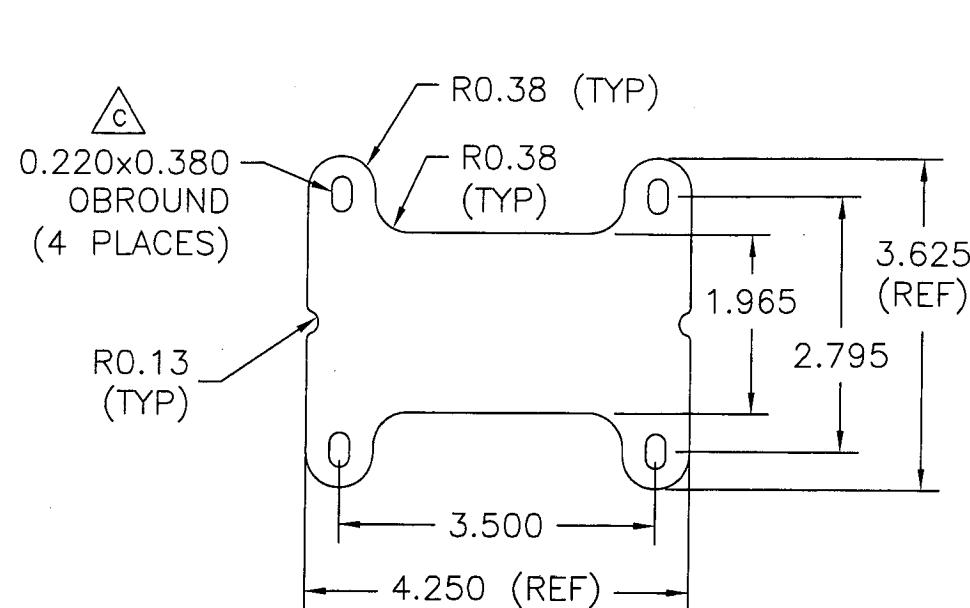
NOTE: Date & initial all entries

PA  
07-04-26

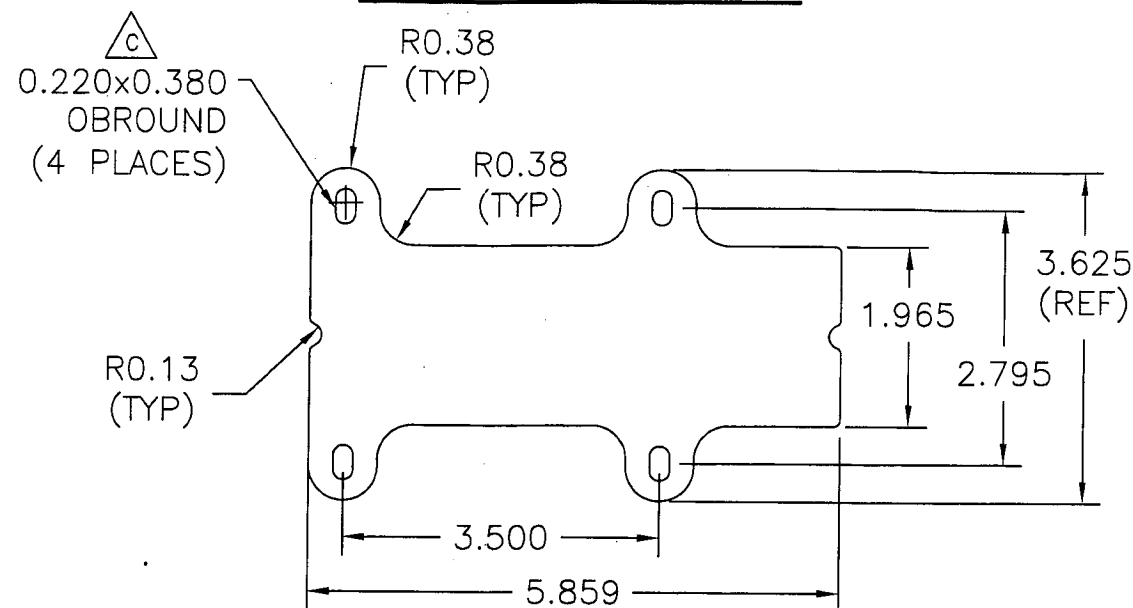
☒ **First Article**      ☐ **Prototype**



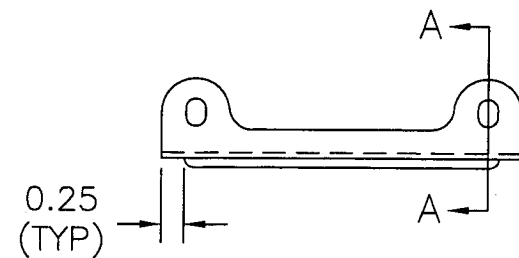
### D3537-1F FLAT PATTERN



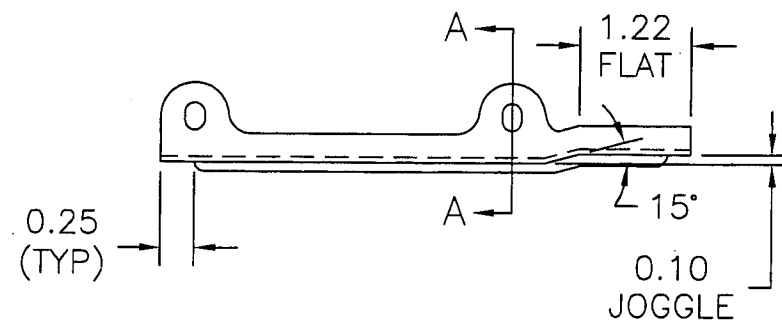
### D3537-3F FLAT PATTERN



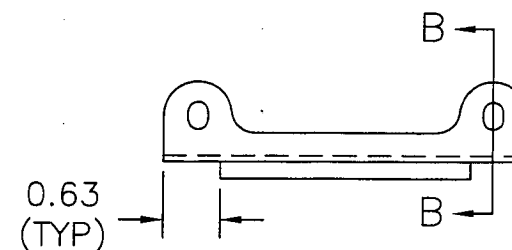
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



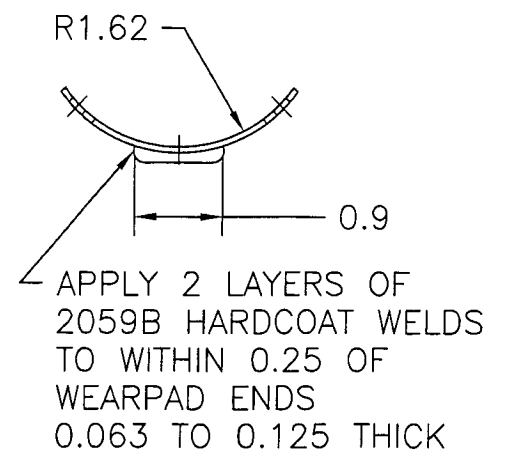
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



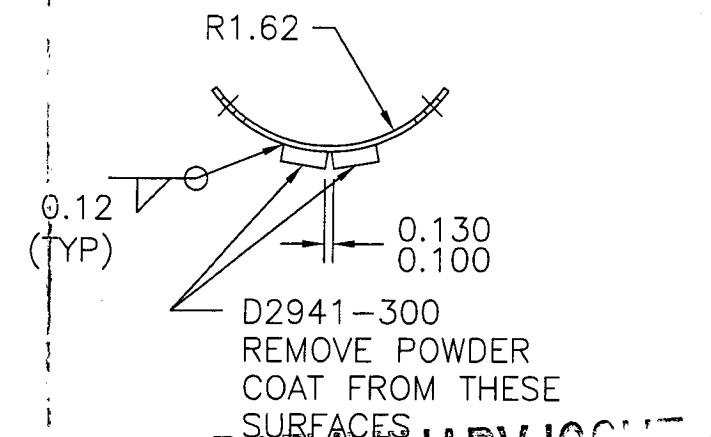
### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

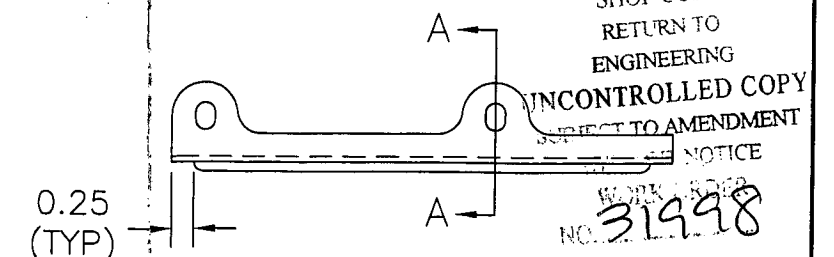
### SECTION A-A



### SECTION B-B



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DART AEROSPACE USA, INC. PORT HADLOCK, WA		DART AEROSPACE USA, INC. PORT HADLOCK, WA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		DRAWING NO. D3537 SHEET 1 OF 1 SCALE 1:2

